

Work Order ID 73993

Tuesday, September 20, 2011 10:26:54 AM



Page 1

Item ID:	K642-511	Accept		Setup	Start	
Revision ID:						
Item Name:	saddle kit 642-511				Stop	
Start Date:	9/20/2011	Start Qty: 3.00				
Required Date:	10/11/2011	Req'd Qty: 3.00				
Reference:						

Approvals:	Process Plan: <u>ME</u>	Date: <u>11-09-20</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9467	Rev A
IIN D206-642	Rev N

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Create White labels per PPP K642-511	CHG004							

Sullivan

For MLT 11-10-3

110		0.00							
	Pick Kit								
Packaging	Memo	0.00							
Packaging									

P 4/10/03 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:26:50 AM

Page 1

Work Order ID: 73993

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev.A 07.06.05 new issue EC
IPP Rev.B 08.02.05, Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C35A BOLT		Purchased	No			110	Each	44.0000	3	9			

Location	Loc Qty	Loc Code
FG	4	
18914	4	
ST353	40	
117872	20	
118628	20	

AN3C36A BOLT		Purchased	No			110	Each	54.0000	9	27			
-----------------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
FG	14	
101261	4	
116590	10	
ST353	40	
118757	40	

AN3C41A BOLT		Purchased	No			110	Each	42.0000	8	24			
-----------------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
FG	4	
103324	4	
ST354	38	
118518	38	

10

117872

1119083

11/10/11 (3)

1118518

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 73993

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 3.00

Required Qty: 3.00

AN4C6A

Purchased

No

110

Each

280.0000

12

36



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

276

116704

15

117872

22

118191

39

118451

200

M/18191 74

M/18451280

AN5C11A

Purchased

No

110

Each

108.0000

8

24



Bolt

Location

Loc Qty

Loc Code

FG

4

104817

4

ST337

70

118706

70

ST338

34

118191

34

118191

AN5C12A

Purchased

No

110

Each

55.0000

4

12



BOLT

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

53

117313

15

118451

38

118451

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 73993

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 3.00

Required Qty: 3.00

AN5C13A

Purchased

No

110

Each

56.0000

4

12



BOLT

Location

Loc Qty

Loc Code

FG

4

18918

4

ST338

52

117313

2

117872

50

1189784x

117313 2x

117872 6x

AN5C15A

Purchased

No

110

Each

72.0000

1

3



Bolt

Location

Loc Qty

Loc Code

ST338

22

118191

22

ST339

50

118267

50

118191

AN5C32A

Purchased

No

110

Each

83.0000

2

6



Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

79

116380

29

117407

25

117969

25

116380

2/10/3 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73993

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 3.00

Required Qty: 3.00

AN5C34A

Purchased

No

110

Each

42.0000

2

6



Location

Loc Qty

Loc Code

FG

2

18918

2

ST340

40

117763

15

117950

25

117763

AN5C35A

Purchased

No

110

Each

54.0000

1

3



Location

Loc Qty

Loc Code

ST340

29

108407

29

ST341

25

118451

25

108407

AN960C10L

NAS1149C0332
R

Purchased

No

110

Each

0.0000

24

72



washer

AN960C416L

NAS1149C0432R

Purchased

No

110

Each

0.0000

24

72



WASHER

AN960C516L

NAS1149C0532
R

Purchased

No

110

Each

0.0000

8

24



WASHER

1118354

1117291

1118389

11/10/3 (3)

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 73993

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 3.00

Required Qty: 3.00

D206-648-013

Handwritten: 67

Manufactured

No

110

Each

2.0000

1

3



GHW Modification



Handwritten: 7391010

Handwritten signature

Handwritten: B7400020

Location

Loc Qty

Loc Code

FG120

2

71578

2

110

Each

106.0000

16

48

D2652

Handwritten: 67

Manufactured

No



Bushing



Handwritten: 73392

Handwritten signature

Location

Loc Qty

Loc Code

FG

44

31985

44

ST

52

53741

0

72120

52

ST019

10

71833

10

D2712

Handwritten: 67

Manufactured

No



Set Screw



30

Handwritten: Pen/143 (3)

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

1411

71160

111

72231

300

73837

1000

*Handwritten: 71160 100
72231 200*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 73993

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 3.00

Required Qty: 3.00

D2932-1

Manufactured No

110

Each

7.0000

1

3



Saddle LH Out, 206



Location

Loc Qty

Loc Code

ST428

7

70874

2

72886

5

110

Each

7.0000

1

D2933-1

Manufactured No



Saddle LH In, 206



Location

Loc Qty

Loc Code

ST421

1

71062

1

ST428

6

72884

6

110

Each

19.0000

2

D2934

Manufactured No



Saddle Spacer



Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

13

70772

13

110

Each

11.0000

2

D2935

Manufactured No



Saddle Spacer



Location

Loc Qty

Loc Code

ST027

11

70770

11

70874 2x
72886 1x

72884
6

B74501 1x

70772 5x
6

B74503 3x R11/10/2 (3)

70770 3x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 73993

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 3.00

Required Qty: 3.00

D2938-1

Manufactured No

110

Each

1.0000

1

3



Saddle LH Out, 206



73468 2x C

Location

Loc Qty

Loc Code

ST428A

1

70862

1

70862 1x

D2939-1

Manufactured No

110

Each

2.0000

1

3



Saddle LH In, 206



73448 2x C

Location

Loc Qty

Loc Code

ST421

1

71056

1

ST428A

1

71873

1

71873 1x

D3396-3

Manufactured No

110

Each

10.0000

2

6



Spacer



73349 C

Location

Loc Qty

Loc Code

FG

10

26772

10

D3407-043

Manufactured No

110

Each

3.0000

1

3



Tow Ring



70982 1x 10/11/10/3 (3)
715752x

Location

Loc Qty

Loc Code

ST463

1

72513

1

ST464

2

68339

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 73993

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 3.00

Required Qty: 3.00

D3456-1

Manufactured No

110

Each

132.0000

1

3



Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

125

66848

3

71165

22

73493

100



71165

D3457-1

Manufactured No

110

Each

42.0000

2

6



Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

32

67779

1

71849

31



71849

D3672-1

Manufactured No

110

Each

1,080.000

24

72



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

1078

64177

86

66821

492

72229

500

ST077

2

52505

2



64177 284

72229 444

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73993

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 3.00

Required Qty: 3.00

D3672-3 Manufactured No

110

Each

1,099.000

24

72



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

1099

64176

180

72230

419

73487

500

22230

D3672-7 Manufactured No

110

Each

746.0000

24

72



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

746

53237

244

64175

50

73488

452

73488

MS21043-3 Purchased No

110

Each

1,086.000

20

60



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1014

118077

34

118614

500

118686

480

1118077

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:26:51 AM

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Work Order ID: 73993



Parent Item: K642-511



Parent Item Name: saddle kit 642-511

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 3.00

Required Qty: 3.00

MS21043-4

Purchased

No

110

Each

1,103.000

13

39



Nut



11/10/3 (3)

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1063

117793

470

118378

93

118686

500

117793

MS21043-5

Purchased

No

110

Each

452.0000

4

12



Nut



11/10/3 (3)

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

332

112314

232

116548

100

ST314

100

118159

100

112314

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L) --
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET ⁽¹⁾
23A					1	1				D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET ⁽¹⁾
24A					1	1				D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET ⁽¹⁾
25A					1	1				D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET ⁽¹⁾
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3873-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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